<b>Work Orde</b> November-09-12	er ID 92830 ? 1:40:36 PM			Page 1							
Revision ID:	D4030-041  Long Basket Assembly (350)		Accept	*N900	<b>040</b>	100	)*	Setup St	1.7	S1*  S2*	
Start Date: Required Date: Reference:	11/09/12 Start Qty: 1.00 11/27/12 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		·				
Approvals:	Process Plan: MLJ	Date: \\\ \_ \O^c	Tooling: SPC (Y/N):		ate:		· . I	Run St St	on	IR1* IR2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	<del></del>
Draw Nbr	Revision Nbr										=
D4030	C									<b>3</b>	
*100 *100* Packaging Packaging	Pick Kit <b>Memo</b>		0.00	e e e e e e e e e e e e e e e e e e e	**		_(X			Sρ 13-4	-24
*110 *110* HandFinish Hand Finishing		abel plate to size of D4086 lar label, apply label ****	0.00  0.00  abel, use scotchbrite red	pad to lightly				φ	( / <u>/</u>	13-4-8	24.
*120 *120* QC	QC5- Inspect part comp  Memo	leteness to step on W/O	0.00		•						
Quality Control			B-4, 2	$\sim$							

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			<b>~</b> .	

									QA Closed:	Dat	e:				
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No.  Part No.  Scrap  Use-as-is  NCR No.  Work Order Update  Rework  Machining  Thermoforming  Large Fab								Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Descri	ption of work order update	Initia	Ac	tion	Sign &						
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	ription	-Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier						-	·								
Training															
Unapproved						<u> </u>			]						
_					F.	AULT CA	TEGORY								
Landi	ng Gear				General				•		,				
	Bending				Bend	Grai			Ovalized		Pressure/Forced				
	Centre N	ot Concer	ntric to (	O/S	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure				
	Cracks			<u> </u>	Broken/Damaged	$\mathbf{H}$	ction Incomplete	<u> </u>	Part Incorre	-	Weld				
	Crushed/CrimpedBurrs				Burrs		ictions Incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock Pulled				
	Cuffs				Contamination	<b>├</b> ──	itenance		Part Moved						
	Heat Treat				Countersink	Misla	beled		Positioned V	Vrong					
	<b>11 11</b>				Cut Too Short	Misr	ead		Power Loss/	Surge	Other				
	Ripples in Bend Drill Holes				Drill Holes	Offse	t								
[	Torque V	Vaves in E	xtrusio	n [	Drawing	Out	f Calibration								
	Turning Sequence Finish					Out	f Sequence								
	Wave/Twist in Tube Folio					Outs	de Dimensions								

Work Order ID 92830  November-09-12 1:40:36 PM					Page 2					
Item ID: Revision ID: Item Name:	D4030-041 Long Basket	Assembly (350)		Accept	*N900	ገ*	Setup Sta	. 14.	S1* S2*	
Start Date: 11/09/1 Required Date: 11/27/1 Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:				••	
Approvals:		lan:		Tooling: SPC (Y/N):		ate:		Run Sta Sta	"[ <b>\]</b> i	R1* R2*
Sequence ID/ Work Center 130 *130* Packaging Packaging	ID	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID 92653	Tool # Plan Code	Accept Qty	Reject Qty		Insp. Stamp
140 *140* QC Ouality Control		QC21- Final Inspection Memo	- Work Order Release	0.00				13		

MG 13-4-24

		DQA:	Date:	
NCR: Ves / No	WORK ORDER NON-CONFORMANCE / UPDATE			•

					V						QA Closed:	Dat	e:		
Work Orde	er: _	- 141	· -			DISPOSITION	,	AGAINST DEPARTMENT/PROCESS  Skid-tube Crosstube Water Jet Engineering							
Part I	-					Rework Scrap Use-as-is Work Order Update	Th	N nerm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other			
Root					Descri	ption of work order update	Initia	Initial Action			Sign &				
Cause		Date	Step	Qty	,	or Non-conformance	Chief 6	Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data															
Equip/Tooling															
Operator			1				1								
Material			<u> </u>									i			
Setup	Ш														
Other	Ш														
Process	Ш														
Supplier	Ш												ļ		
Training	Ш						1								
Unapproved	Ш		İ				<u> </u>								
					<u></u>	. F.	AULT CA	ATEG	ORY						
Landi	ng G	ear				General					,	-			
	$\vdash$	Bending				Bend	Gra				Ovalized	1	Pressure/Forced		
	$\vdash$	Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	dwar			Over/Under	- <del>-</del>	Temperature/Cure		
	$\vdash$	Cracks			<u> </u>	Broken/Damaged	$\boldsymbol{\vdash}$		on Incomplete		Part Incorre		Weld		
	-	Crushed/0	Crimped,			Burrs	$\vdash$		ons Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
	Щ	Cuffs			_	Contamination	$\vdash$		nance		Part Moved				
	$\vdash$	Heat Treat				Countersink	Mis	label	ed		Positioned V	T T	<del>_</del>		
	lacksquare	Inspection		Tube	<u> </u>	Cut Too Short	$\vdash$	read			Power Loss/	Surge	Other		
	Ripples in Bend					Drill Holes	Offs								
1	Torque Waves in Extrusion					Drawing	<del></del>		alibration						
	Turning Sequence					Finish	Out of Sequence								
	Wave/Twist in Tube					Folio	Out	tside l	Dimensions						

## **Picklist Print**

November-09-12 1:40:35 PM

Work Order ID:

92830

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date:** 11/09/12

Required Date: 11/27/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

10.04.20 verified by:EC

IPP Rev:B as per dwg revB DD IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

	IPP Rev D 12.03.2	7 per NCR 12-123	9 EC	verified by:JLl	M -								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qt <u>y</u>	Qty Issued	Date Issued	Status
02530 Handle Weldment		Manufactured	No			100	Each	8.0000	1	0	B81	03V	A &
				Location		Loc Oty	<u>Lo</u>	c Code					•
	٠			ST255		6							
				921	29	6							
				ST506		2							
				828		1							
				834	23	1				7			
<b>2535</b> pring		Manufactured	No			100	Each	120.0000	2	(2)	<i>\$</i>	374	24
<i>p.</i> g				Location		Loc Oty	Lo	c Code					
				ST011		120							
				835	45	3							
				863		67							
				925		50					~~ ~-	<b>—</b> ()	_
2537		Manufactured	No			100	Each	74.0000	2	ورك	ピクン-	+//	<
ushing									<del></del>		· · · · ·	<u> </u>	<del>-0</del>
•				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				ST012		74							
				855		32							
				868		2							
2012.041			NT-	875		40	Each	0.0000					
3913-041	250	Manufactured	No	$Q_{i}$	2824	100	Each	0.0000	1	/ <sup>1</sup>	1512	13-1	4-24.
ong Basket Base Assemb 3914-041 ong Basket Lid Assembly		Manufactured	No	q	2816	100	Each	0.0000	1 /	, 1	BI	13-4	4r DL. 1-24.

DQA:	Date:	

NCR: Y	·													
						<u>,                                      </u>					QA Closed:	Date	:	
Work Orde	er: _					DISPOSITION	-		a	AGAINST DE	PARTMENT,	_	Engineering	
Part N NCR N	_					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing				ab Prod. Eng. Coor. Q ng Rec/Store/Packaging 0			
Root	T	<del> </del>			Descri	ption of work order update	Ini	itial	Ac <sup>-</sup>	tion	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												•		
						<del></del>	AULT	CATE	GORY					
Landin	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	H Ir	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Wave/Twist in Tube					Folio	По	utside	Dimensions					

Work Order ID:	92830									
Parent Item:	D4030-041						Sta	rt Date: 11/09/12	2	Required Date: 11/27/12
Parent Item Name:	Long Basket Assembly (350)						St	art Qty: 1.00	~	Required Qty: 1.00
<b>D3917-3</b> Washer	Manufactured	No			100	Each	41.0000	6	6	3946438
			Location		Loc Qty		Loc Code			-
			ST072		41					
			. 8	8370	41					_
D3953-3 Gas Spring Stud, Lid	Manufactured	No			100	Each	47.0000	2	$\binom{2}{}$	) 13747448P
			Location		Loc Qty		Loc Code			
			GA		1					
			8	7592	1					
			ST076		46	<u>,</u>				
				8494	26					
			8	9337	20					
D3953-7 Spring Spacer	Manufactured	No			100	Each	51.0000	2	(2)	B94681 SP
			Location		Loc Qty		Loc Code			·
			ST076		51					
			8	37444	15	i				
				8393	24					
			8	39248	12				A	
D3953-9	Manufactured	No			100	Each	45.0000	2	$(\frac{1}{2})$	R9/17/19 CO
Gas Spring Washer								e ·		DIGHTON.
			<b>Location</b>		Loc Oty		Loc Code			13-4-21
			ST076		45	5		·		10 9
•				8462	15					·
			8	9307	30	)		·		

										DQA:	Date:	· .
NCR: \	Yes	/ No				WORK ORDER NON-	CONFOR	QA Closed:	Date:			
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator			1									•
Material												
Setup												
Other												
Process												
Supplier												
Training										ļ		
Unapproved												
						F	AULT CAT	EGORY		•		
Landir	ng G	ear				General					-	

BOM/Route Hardware Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Contamination Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Out of Calibration Drawing Finish Turning Sequence Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Grain

Pressure/Forced

Ovalized

Bending

Bend

Work Order ID:	92830								
Parent Item:	D4030-041					Start	Date: 11/09/12	Require	ed Date: 11/27/12
Parent Item Name:	Long Basket Assembly (350)		,			Star	t Qty: 1.00	Requir	ed Qty: 1.00
D3953-17 Gas Spring Spacer	Manufactur	red No		100	Each	51.0000	2	2	B74578
			<b>Location</b>	Loc Qty		Loc Code			01
	•		ST077	47					
			88281	21					
			89180	26				· ·	
			ST078	4					
			87291	4					
D3953-19 Gas Spring Bracket	Manufactur	red No		100	Each	11.0000	1	(1) B	7281980
			Location	Loc Qty		Loc Code			•
		-	ST077	11					
			82938						
			88269	10					
D3953-21 Gas Spring Bracket	Manufactur	ed <sup>No</sup>		100	Each	16.0000	1	<u> </u>	B941468F
			Location	Loc Qty		Loc Code			
			ST077	16					
			85759						
D3969-3 Spring (Basket Lid)	Manufactur	red No		100	Each	28.0000	1	1 5	ρ
			Location	Loc Qty		Loc Code			•
			ST262	28					
			64285						
			82942						
			91844	20					
AN3-14A Bolt	Purchased	No	•	100	Each	105.0000	4	4 m	12375780
			Location	Loc Qty		Loc Code		12	
			ST512	105		<del></del>		()	-4-07.
			12170						
			12280						

			DQA:	Date:	
				_	
CD.	Voc / No	WORK ORDER NON-CONFORMANCE / LIDDATE			

NC

NCN.					WORK ORDER WORK		WINAITCE / OI	DATE	QA Closed:	Date	:
Work Orde	r:	<u> </u>			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N		-			Rework Scrap	]	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0	<del></del>		<del></del>	Use-as-is Work Order Update	] The	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &	 	
Cause	Date	Step	Qty	(	or Non-conformance	Chief Er	g Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material											
Setup	_										
Other	_										
Process											
Supplier Training	$\dashv$								}		
Unapproved											
onapproved 1		<b></b>	L		<u> </u>	AULT CAT	EGORY		Ļ	1	1
Landin	g Gear				General		· · · · · · · · · · · · · · · · ·				
Γ	Bending				Bend	Grain	1		Ovalized	Γ	Pressure/Forced
[	Centre No	ot Concei	ntric to O	/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
Γ	Crushed/	Crimped.			Burrs	Instru	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	tenance		Part Moved	_	
	Heat Trea	ıt			Countersink	Misla	beled		Positioned V	Wrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes	Offse	t				
,	Torque W	aves in E	xtrusion		Drawing	Out o	f Calibration				
	Turning S	equence			Finish	Out	f Sequence				

Outside Dimensions

Wave/Twist in Tube

92830 D4030 041							Stant	Data: 11/09/1	<b>,</b>	Required Date: 11/27/12
	hl. (250)								-	Required Qty: 1.00
Long Basket Assem								- •		Required Qty. 1.00
	Purchased	No			100	Each	131.0000	2	2	m 123900.8f
			<b>Location</b>		Loc Qty		Loc Code			
			ST512		131					
					47					
					1					
				122407						m124805
	Purchased	No			100	Each	132.0000	4	4	n DUXCE
										7///04003
			Location		Loc Qty		Loc Code			
			338		4					
				121181	4					
			ST337		88					
					50					
				122800	38					
			ST338		40					
				122151						
	Purchased	No			100	Each	90.0000	3	3	SP
			Location		Loc Oty		Loc Code			01
			ST356		88					
				122800	88			3	<del>\</del> _	
			ST357	<u></u>	2				· ·	
				118626	1					
				121652	1					
	Purchased	No			100	Each	63.0000	3	3	7/24221 8P 13-4-24.
			Location		Loc Otv		Loc Code			12-11-211
										10 4 09.
				122800						
			0772.4.4					*****		
				121349	2					
	D4030-041	D4030-041 Long Basket Assembly (350) Purchased  Purchased	D4030-041 Long Basket Assembly (350) Purchased No  Purchased No  Purchased No	D4030-041 Long Basket Assembly (350) Purchased No Location ST512  Purchased No Location 338 ST337  Purchased No ST337  ST338  Purchased No Location ST356 ST356  Purchased No Location ST356 ST357  Purchased No ST357  ST342 ST344	D4030-041 Long Basket Assembly (350)  Purchased No    Location   ST512   117441   118628   122407     Purchased No   Location   338   121181   ST337   122416   122800   ST338   117872   122151     Purchased No   Location   ST356   122800   ST356   122800   ST356   122800   ST357   118626   121652     Purchased No   Location   ST357   118626   121652     Purchased No   Location   ST357   118626   121652     Purchased No   Location   ST342   122800   ST344	D4030-041   Long Basket Assembly (350)   100   100   100	D4030-041   D408   D4	December   Purchased   No	Decision   Decision	December   Purchased   Purch

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	<del></del>
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR	No.	,				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		•			Descri	ption of work order update	1	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY			-	
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. It n Strip in		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabe Misread	on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing ·	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes		Offset -					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	92830									
Parent Item:	D4030-041						Start D	ate: 11/09/12		Required Date: 11/27/12
Parent Item Name:	Long Basket Assembly (35	50)			•		Start C	<b>Qty:</b> 1.00		Required Qty: 1.00
<b>AN310C4</b> Nut	Purc	chased	No		100	Each	75.0000	2	2	mAYZZISP
			<u>Locatio</u>	<u>n</u>	Loc Oty		Loc Code			•
			ST343		73					
				122800	23					
				122993	50					
			ST344		2					
				120360	1					
				121166	1				<del></del>	
MS21042L3	Puro	chased	No		100	Each	2,433.0000	6	6	m 124291 Sp
Nut									· · · · · ·	M 124271 Sp 13-4-24
			<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code			13-4-24
			316		619			-		,
				122452	619					
			ST300		225					
				117885 119017	32					
				119017	55 138					
			ST314	117075	1268					
			31314	123265	1268					
			ST317	123203	321					
			31317		321					

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFOR	MANCE / UP	DATE			_		
						·		_				QA Closed:	Da	te:	
Work Ord	er:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root	-				Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desci	ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training			`												
Unapproved			<u></u>				L				l				
			<del> </del>				AUL	T CATE	GORY						
Landi	ng (	1				General		10			_	O -15d			10
	-	Bending Centre No	at Canaar	atria ta (	\( \rightarrow \ri	Bend BOM/Route	$\vdash$	Grain Hardwa		F	$\dashv$	Ovalized Over/Under	taloranco	-	Pressure/Forced Temperature/Cure
	<u> </u>	Cracks	or concer	itric to t	<sup>3/3</sup>  -	Broken/Damaged	-	4	on Incomplete	-	-	Part Incorred		$\vdash$	Weld
		Crushed/	Crimned	•	-	Burrs	$\vdash$	1	ions Incomplete/I	Inclear		Part Lost/Mi		$\vdash$	Wrong Stock Pulled
	$\vdash$	Cuffs	compeu.		<b>—</b>	Contamination	H	Mainte	•		⊣	Part Moved	23111B	<u> </u>	1 one stock i alled
		Heat Trea	t			Countersink	$\vdash$	Mislabe		-	-4	Positioned V	Vrong		
		Inspection		Tube		Cut Too Short		Misread				Power Loss/	•		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	92830							
Parent Item:	D4030-041					Start D	ate: 11/09/12	Required Date: 11/27/12
Parent Item Name:	Long Basket Assembly (350)	•				Start (	Qty: 1.00	Required Qty: 1.00
MS21042L5 Nut	Purchased	No		100	Each	1,041.0000	4	4 m/23900 8f
·		Loca	<u>tion</u>	Loc Qty		Loc Code		
		300		29				
			121652	29				
		314		932				
			122452	932				
		ST30	0	80				
			108827	4				
			116105	1				
			116548	43				<del></del>
			119109	20				<del></del>
-		NI	2937	120		226.0000		
MS24665-151	Purchased	No		100	Each	236.0000	3	<sup>3</sup> 💭
Cotter Pin								01:
		<u>Loca</u>		Loc Qty		Loc Code		
		ST32		236				
			122802	162			2	<u>54</u>
			17566	74				<u> </u>
MS24665-300	Purchased	No		100	Each	79.0000	2	2 W DUSSE CO
Cotter Pin							<u> </u>	11104333
		Loca	<u>tion</u>	Loc Qty		Loc Code		13-4-24
		GA		75				15 9- 29
			118234	75				<u></u>
		ST30	9	4				
			116823	4				

NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE /	<b>UPDATE</b>

DQA:	Date:	

						<u> </u>					QA Clos	ed: [	ate:	
Work Orde	or.					DISPOSITION				AGAINST D	EPARTME	NT/PROCESS		•
Part N	۱o.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstul  Machining Small Fa  Thermoforming Finishin  Large Fab Composi			I	Water Je Prod. Eng. Coo Store/Packagin Supplie	r. g	Engineering Quality Quality Other
Root					Descri	ption of work order update	Ir	nitial	Ac	ction	Sign 8	k		
Cause		Date	Step	Qty	(	or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verificat	ion	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training													ž.	
Unapproved				<u>!</u>			<u> </u> :Δ111.7	CATE	GORY		<u> </u>			
Landir	ng G	Sear				General	AUL!	CATE				•		
		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in	Crimped. It In Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	/Unclear	Part Inco Part Lost Part Mod Position	der tolerance orrect :/Missing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	_	Turning S		xtrusioi	¹	Drawing Finish	-		Calibration		<del></del>			
	_	Turning Some Wave/Tw		ıe	<del> </del>	Folio	$\vdash$		Sequence Dimensions					
L		17470/100	150 111 140			1.000		Catalac	- D.I.ICI 1310113					

Work Order ID: Parent Item: Parent Item Name:	92830 D4030-041 Long Basket Assembly (350)						Date: 11/09/12 Qty: 1.00		Required Date: 11/27/12 Required Qty: 1.00
NAS1149F0432P Washer	Purchased	No		100	Each	476.0000	6	6	m 124580 St
		<u>L</u>	<u>ocation</u>	Loc Qty		Loc Code			
		27	75	248					
			122441	248					
		S	Г275	28					
			121350	15					
			122151	13					
		. S'	Γ295	200					
			123522	200					
NAS1149F0563P	Purchased	No		100	Each	826.0000	4	4	CQ
Washer							OW - 1811	-151 . WW1	<del></del>
		<u>L</u>	<u>ocation</u>	Loc Oty		Loc Code			
		S	Г275	826					
			121350	826				LX_	
NAS1149F0332P WASHER	Purchased	No		100	Each	1,182.0000	8	8	M123900
		<u>L</u>	<u>ocation</u>	Loc Qty		Loc Code		•	See 13-4-24
		2	75	206					
			122441	206					
		S	Γ275	776					
			117735	13					
			119225	8					
			121259	138				<del></del>	
			121825	14					
			122063 17317	600				<del></del>	
		0							
		S	T295	200	•				
			123352	200			<u> </u>		

	DQA:	Date:	
MODE ORDER MONECONICORMANICE / LIROATE			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

				·					QA Closed:	Date			
Work Orde	/ork Order:						AGAINST DEPARTMENT/PROCESS						
Part No					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator													
Material		İ											
Setup								,					
Other		1											
Process													
Supplier													
Training		1			•	ļ							
Unapproved		<u> </u>								<u> </u>			
					F	AULT CATE	GORY						
Landin	g Gear			<u></u>	General			<b></b>	,	-	<b></b>		
	Bending			<u> </u> _	Bend	Grain			Ovalized	_	Pressure/Forced		
	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Hardw			Over/Under	<u> </u>	Temperature/Cure		
-	Cracks			_	Broken/Damaged		ion Incomplete	ļ	Part Incorrect		Weld		
-	Crushed/	Crimped.		<u> </u>	Burrs	$\vdash$	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled		
-	Cuffs				Contamination	Maintenance			Part Moved				
-	Heat Treat			<u> </u>	Countersink	$\vdash$	Mislabeled			Positioned Wrong			
-	Inspection	-	Tube	·	Cut Too Short	Misrea	d		Power Loss/	Surge	Other		
-	Ripples in				Drill Holes	Offset							
-	Torque W			י	Drawing	<b>⊢</b>	Calibration -						
-	Turning S	•		ļ.	Finish	<del></del>	Sequence						
	Wave/Twist in Tube			1	Folio	Outside	e Dimensions						

Work Order ID:

92830

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

NAS1149C0432R

Washer

Purchased

No

**Start Date:** 11/09/12

Required Date: 11/27/12

Start Qty: 1.00

Required Qty: 1.00

4,340.0000 2 2

Location		Loc Qty	Loc Code	
296		3000		<del></del>
12	22441	3000		- <del>}</del> x
ST297		1036		·
11	17291	40		
11	19124	996		
ST298		304		
12	21255	304		

Each

100

												DQA:	Dat	e: _	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UF	PDATE			_		
												QA Closed:	Dat	e:	····
Work Order:						DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part No				Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other		
2	1		<del> </del>	· · · · · · · · · · · · · · · · · · ·	Danasi	nation of words and an undertail		nitial	Δ.	ction		Cian 9	· · · · · · · · · · · · · · · · · · ·	_	
Root Cause	į	Date	Step	Qty		ption of work order update or Non-conformance		iniciai iief Eng	h .	cription		Sign & Date	Verification		QC Inspector
Doc/Data	П	·	эсер	Q.,		or troit comormance	+="	Critici Erig		- I Peron					
Equip/Tooling	П														
Operator	П														
Material	П														
Setup			Ì											ĺ	
Other															•
Process			į												
Supplier	Ш		ļ		i										
Training												,	-		
Unapproved			<u> </u>												
						F	AUL	T CATE	GORY						
Landi	ng G	iear				General				•		-	-		
	Ш	Bending				Bend		Grain			L	Ovalized	1		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	ire		L	Over/Under	tolerance		Temperature/Cure
Cracks				Broken/Damaged		Inspection Incomplete				Part Incorred	ct		Weld		

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish

	ITEM	QTY -041	QTY -043	P/N	DESCRIPTION	Γ			
		Х		D4030-041	LONG BASKET ASSY (350)	1			
			Х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)	1			
					(***)	1			
	1	1	1	D2530	HANDLE WELDMENT	1			
	2	2	2	D2535	SPRING	1			
D	3	2	2	D2537	BUSHING	1			
	4	1	1	D3913-041	LONG BASKET BASE ASSY (350)	ET BASE ASSY (350)			
	5_	1		.D3914-041	LONG BASKET LID ASSY (350)	1_			
	6		1	D3915-041	LIGHT LID ASSY-LONG BASKET	1			
	7	6	6	D3917-3	WASHER	1			
	8	2	2	D3953-3	GAS SPRING STUD, LID	i			
	9	_ 2	2	D3953-7	GAS SPRING SPACER	ĬŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢŢ			
	10	2	_2	D3953-9	GAS SPRING WASHER	1			
	11	2	2	D3953-17	GAS SPRING SPACER	1			
	12	. 1	1	D3953-19	GAS SPRING BRACKET	1			
	13	1	1	D3953-21	GAS SPRING BRACKET				
	14	1	_1	D3969-3	SPRING	1			
	15	4	4	AN3-14A	BOLT				
	16	2		AN3-16A	BOLT	1			
	17		2	AN3-20A	BOLT	1			
	18	3	3	AN4-12	BOLT (DRILLED)				
С	19	4	2	AN5-17A	BOLT				
	20		2	AN5-21A	BOLT				
	21	3	3	AN310-4	NUT, CASTELLATED				
	22	2	2	AN310C4	NUT, CASTELLATED				
	23	6	6	MS21042L3	NUT				
	24	4	4	MS21042L5	NUT				
	25	3	3	MS24665-151	COTTER PIN				
	26	2	2	MS24665-300	COTTER PIN				
-	27	6	6	NAS1149F0432P	WASHER				
	28	4	4	NAS1149F0563P	WASHER				
	_30	8	8	NAS1149F0332P	WASHER				
ļ	31	2	2	NAS1149C0432R	WASHER				
			<u>&amp;</u>		OLIVAN ANDE				

SHOP COF RETURN T **ENGINEEF** UNCONTROLI SUBJECT TO A WITHOUT WORK ( NO. 97.830 MLJ (2-11-09

D4030-043 LONG BASKET ASSY, LIGHT LID (350) (MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596 QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); OTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).

ANS-21A BOLT WAS ANS-19A: BOM & (D3-3) MB 10.07.23 В JPH 10.04.06 Α NEW ISSUE JPH 10.03.16 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. C D4030 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE LONG BASKET ASSY (350) NT

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PRED DOLLAGET REMINER AND STORE AND ERIOSPACE TO

NOT TO BE USED FOR ANY PARKED OF CORPORATION OF THE OWNER AND STORE DOCUMENT OF THE OWNER AND STORE DOCUME DE APPR. DATE 10.07.23

D4030-041 LONG BASKET ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY)

D

С

В

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX

7) WEIGHT: -041: 72 lbs APPROX -043: 57 lbs APPROX

3



